

Fire Red.

Dart Aerospace Ltd.

Date: Monday, 05/01/2009 7:58:17 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PIN ASSEMBLY
 Job Number : 44366
 Estimate Number : 11341
 P.O. Number :
 This Issue : 05/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 44244
 Written By :
 Checked & Approved By : JLD 09.01.05
 Comment : Est: A 05.01.13 New issue KJ/JLM

Part Number : D3332043
 Drawing Number : D3332 REV. A1
 Project Number : N/A
 Drawing Revision : A1
 Material :
 Due Date : 31/01/2009 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1018R0500 1018-1025 round bar .500



Comment: Qty.: 0.1749 f(s)/Unit Total: 1.7493 f(s)
 1018-1025 Steel Bar
 Material: AISI 1018-1025 Ø0.500" Round Bar
 (M1018-R0.500)
 Identify for D3332-7
 Batch: M106966

09/01/07

(10 pcs)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
 Machine D3332-7 as per Folio FA493 and Dwg D3332

09/01/07

(10 pcs)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/01/07

(10 pcs)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

M.A 09/01/08

(10 pcs)

5.0 M1018R0313 1018-1025 round bar .313



Comment: Qty.: 0.2836 f(s)/Unit Total: 2.8361 f(s)
 1018-1025 Steel Bar
 Material: AISI 1018-1025 Ø0.313" Round Bar
 (M1018-R0.313)
 Identify as D3332-9
 Batch: M107436

09.01.13

(x10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification - Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/01/2009 7:58:17 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 44366

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Fabricate D3332-9 as per Dwg D3332

Pl 09-01-13

(X10)

7.0

D33321

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
Handle Assembly
Pick:
Qty Part Number Description Batch
1 D3332-1 Handle *345080-1*
A/R N/A Steel Rod *344400✓*
Identify as D3332-043 *M105138*

Pl 09-01-13

(X10)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble and Weld using D3332-041T1 as per Dwg D3332

Pl 09-03-02

(X10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/03/03 (X10)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-03

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
Cover thread only for D3332-9 prior to painting

START TIME: *8:25*
OVEN TEMPERATURE: *320°*
FINISH TIME: *8:55*

CMO/FZ

(X10) 09/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/01/2009 7:58:17 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 44366

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gl



Comment: INSPECT POWDER COAT

09-03-23

(10)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl

Pg 3/23

(10)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



MF 09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

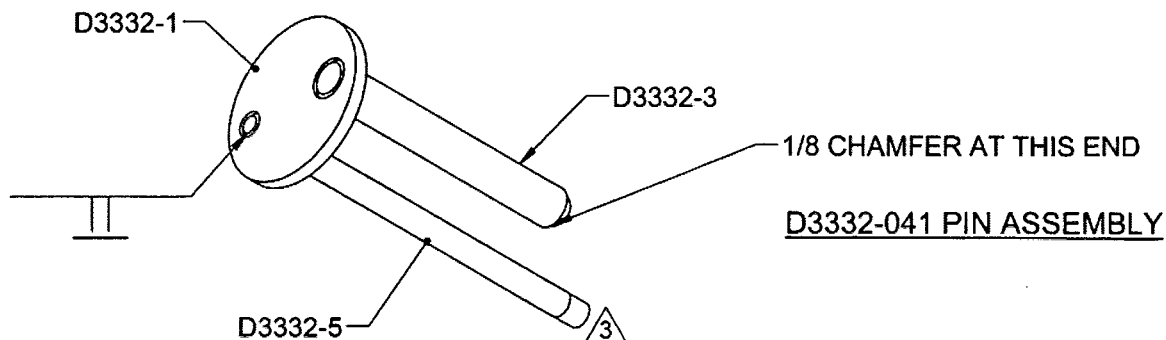
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

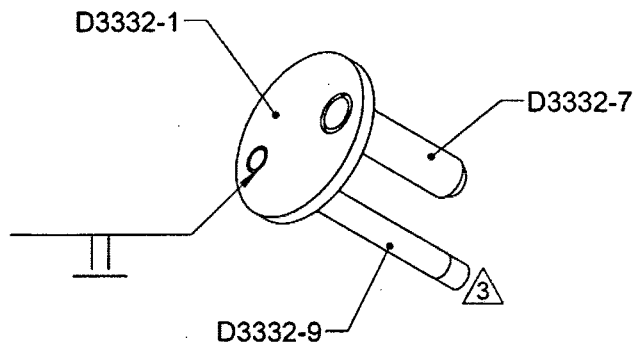
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE TO 0.000 -0.005	



D3332-041 PIN ASSEMBLY

RELEASED
[Signature]
05/02/09



D3332-043 PIN ASSEMBLY

NOTES:

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

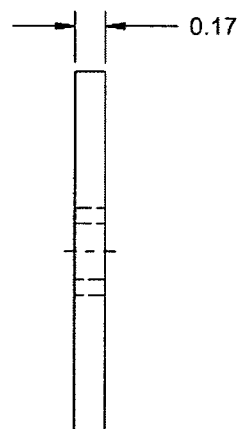
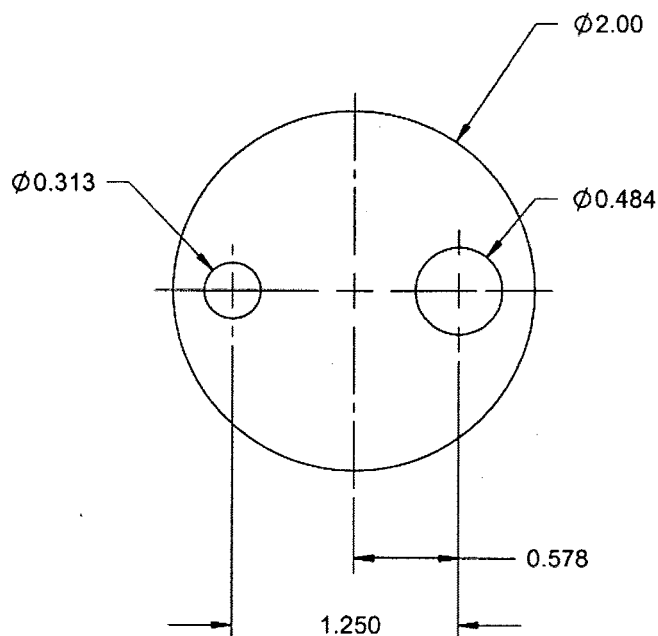
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



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[Signature]
05/04/09

D3332-1 HANDLE

NOTES:

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

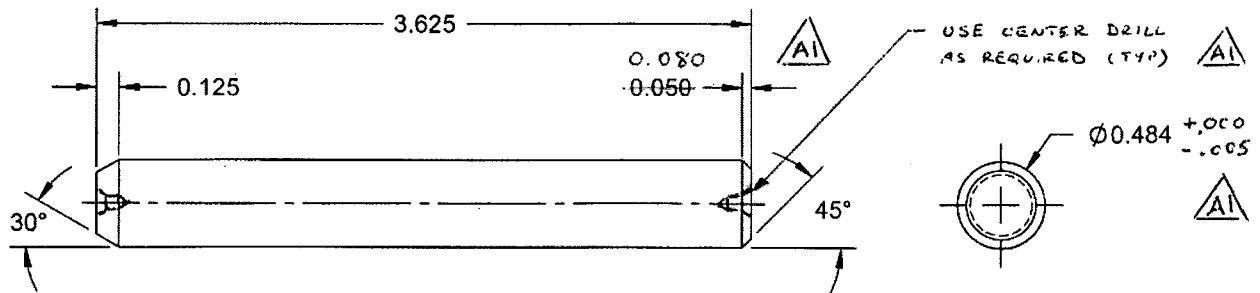
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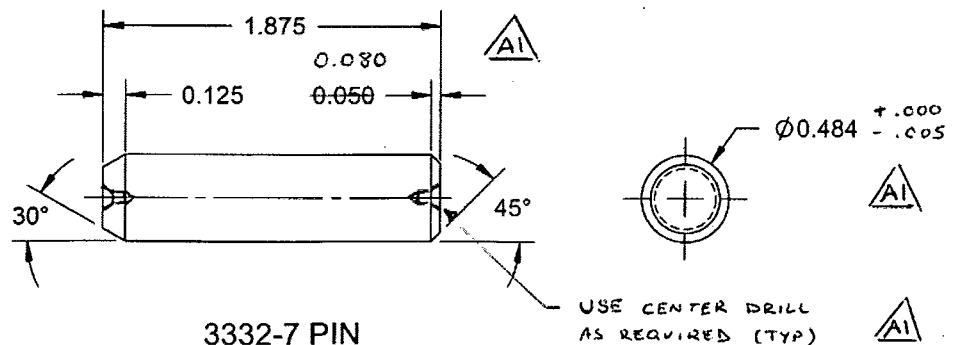
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**3332-3 PIN**

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[Signature]
05/02/09

**3332-7 PIN****NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

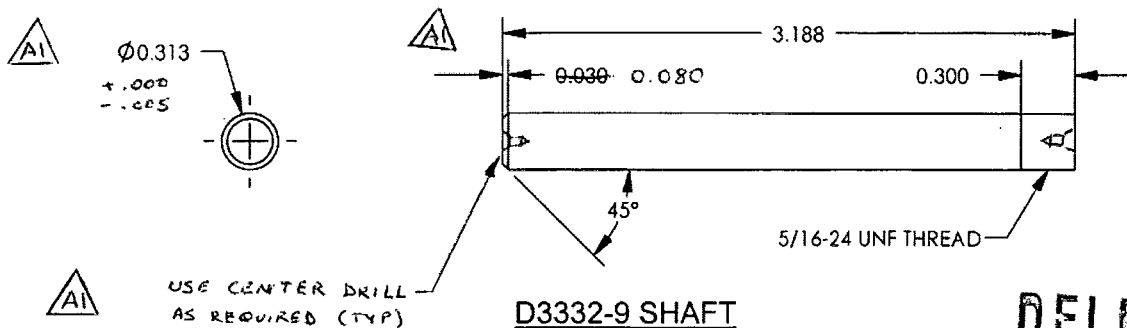
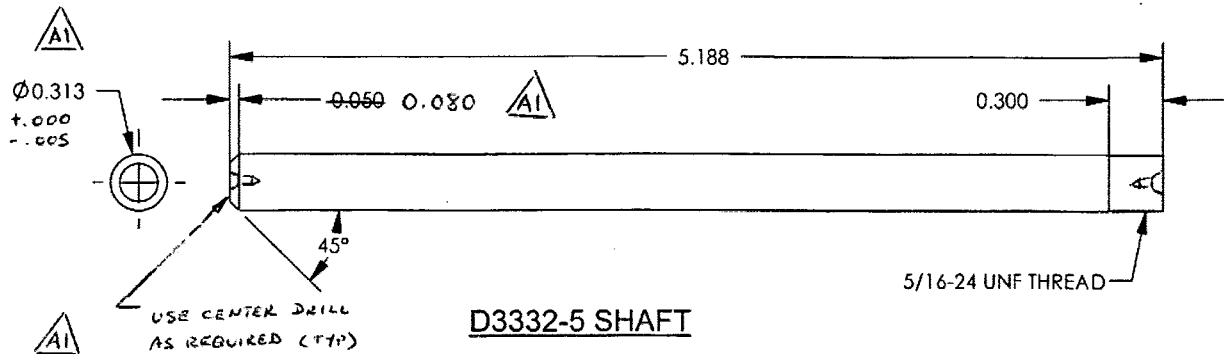
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



RELEASED
AS
05/02/09

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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